

Claims

1. Device for producing blanks using a rotary cutting apparatus, wherein the cutting apparatus has a downstream delivery system for defined sorting of the blanks, characterized in that faulty blanks (1, 2) are not disposed in the stacking means (23-27) but supplied to a waste means.
2. Device according to claim 1, characterized in that a transfer system, such as e.g. a suction belt means (17), is disposed downstream of rotary cutting.
3. Device according to claim 1, characterized in that the blanks (1, 2) on the suction belt means (17) are separated from the waste strip or waste grid (16).
4. Device according to claim 1, characterized in that the waste (16) is separated directly from the blanks (1, 2) immediately downstream of the cutting apparatus (13) by removing it over the surface of the cutting cylinder (14).
5. Device according to claim 1, characterized in that, after cutting, the waste grid (16) is guided over the surface of the counter pressure cylinder (15), downwards into a suction funnel (17), thereby separating the blanks (1, 2) from the waste (16).
6. Device according to any one of the preceding claims, characterized in that a chopper (18) is disposed downstream of the cutting apparatus (13).

7. Device according to any one of the preceding claims, characterized in that any number of blanks (1, 2) is disposed on the suction belt means (17), with an optical test device (20) being disposed thereabove for detecting printing faults or missing blanks (1, 2).
8. Device according to any one of the preceding claims, characterized in that a suction cup belt (21) is disposed downstream of the cutting apparatus (13) for receiving the blanks (1, 2) from the suction belt means (17).
9. Device according to any one of the preceding claims, characterized in that individual suction cups (22) are disposed on the suction cup belt (21).
10. Device according to any one of the preceding claims, characterized in that the suction cups (22) on the suction cup belt (21) have the same mutual separations as the blanks (1, 2) along the product web.
11. Device according to any one of the preceding claims, characterized in that the suction cups (22) on the suction cup belt (21) have different mutual separations than the blanks on the product web (3).
12. Device according to any one of the preceding claims, characterized in that the suction cups (22) may be disposed on the suction cup belt (21) with any separation therebetween.
13. Device according to any one of the preceding claims, characterized in that the suction belt means (17) has at least one downstream stacking means (23).

14. Device according to any one of the preceding claims, characterized in that the stacking means (23) has a vacuum wheel (28), vacuum belts (29) and/or a delivery wheel (30).
15. Device according to any one of the preceding claims, characterized in that the delivery wheel (30) is either formed as vacuum drum or delivery star.
16. Device according to any one of the preceding claims, characterized in that at least two delivery wheels (30) are disposed next to each other on an axis, each delivery wheel (30) having a different diameter.
17. Device according to any one of the preceding claims, characterized in that delivery nests (31) are disposed below the delivery wheel (30), onto which the blanks (1, 2) are disposed at different heights.
18. Device according to any one of the preceding claims, characterized in that the individual nest layers are pushed on top of each other to form a sorted stack (4) by displacing the delivery nests (31) against a lateral stop (32).
19. Device according to any one of the preceding claims, characterized in that the product web (3) is printed in a predetermined transverse and longitudinal order.
20. Device according to any one of the preceding claims, characterized in that a pushing device (33) pushes the sorted stack (4) onto a transport belt (34).

21. Device according to any one of the preceding claims, characterized in that faulty blanks (1, 2) are transferred to a suctioning means (36) at the suction cup wheel (35).
22. Device according to any one of the preceding claims, characterized in that, in dependence on the control of the suction cups (22), different blank rows are received and supplied in rows to one of the stacking means (23-27), where they are placed, thereby mixing them in any fashion.
23. Device according to any one of the preceding claims, characterized in that in one embodiment, which is not shown, each individual suction cup (22) can be controlled directly e.g. via a bus system, which permits distribution of individual blanks (1, 2), received in rows, onto several stacking means (23-27), thereby mixing them.
24. Device according to any one of the preceding claims, characterized in that any number of stacking means (23) can be consecutively disposed.
25. Device according to any one of the preceding claims, characterized in that the machine (5) has a print mark control (19) to permit the rotary cutting apparatus (13) to cut out the blanks (1, 2) exactly in register with the product web (3).
26. Device according to any one of the preceding claims, characterized in that the machine (5) can be individually used as an offline machine or as inline machine which is directly connected to other machines.